



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2857-1
Job Sheet 185556



Part No: D2857-1

Job Qty: 10 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-1		DAS 18/11/18
100	Bandsaw	10 pcs	11/9/18	11/9/18	0.00	0.35	Bandsaw1		52 18/11/18
110	CNC Vertical Machining	10 pcs	11/9/18	11/9/18	0.13	5.53	HAAS1-2	Kt.	9-89 18/11/18
130	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-1		18/11/18
140	HandFinish	10 pcs	11/9/18	11/9/18	0.00	0.22	HandFinish1		18/11/18
160	Powdercoat	10 pcs	11/9/18	11/9/18	0.00	0.15	Powdercoat1		18/11/18
170	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC3		18/11/18
180	Packaging	10 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1	5702	NOV 15 2018
190	QC21-SA	10 Ea	11/9/18	11/9/18	0.00	0.00	QC21		NOV 15 2018

Part Op 100 - Cut blanks 4.425"

Descriptions: 110 - 1-Machine per folio FA940 DWG REV: _____ 2-Deburr any rough edges

M138951 160 - START TIME: 9.16 FINISH TIME: 9.40

TEMP: 320°

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X2.000	6061T6 Bar 1.250 X 2.000	3.7000 ft (.37 ea)	90-Start up Operation	5105838 5124828

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.250X2.000	4	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches ± 0.010	4.310 4.290	4.298	
2	Hinge Bracket	4.000inches ± 0.010	4.010 3.990	4.001	
3	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	0.340	
4	Hinge Bracket	1.110inches ± 0.005	1.115 1.105	1.110	
5	Hinge Bracket	1.790inches ± 0.010	1.800	1.790	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By Lead hand / Supervisor Approval Verification
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S124831 Part: D2857 - 1 Job No: 185556 Serial No/Batch: S124831 Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/06/18		

Root Cause					
Environment ☐	No Re-verification ☐	Press ☐			Positioned Wrong
Design ☐	Operator ☐	Bench ☐			Outside Dimensions
Doc/Data ☐	Offset/Setup ☐	Center ☐			Over/Under tolerance
Equip/Tooling ☐	Supplier ☐	Crack ☐			Part Incorrect
Handling/Pre ☐	Training ☐	Critical ☐			Part Lost/Missing
Material ☐	Use for Testing ☐	Cut ☐			Part Moved
Internal Transport ☐	Poor Information ☐	Crack ☐			Drawing
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐			Finish
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			Misread
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			Turning Sequence
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER: ☐			

6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315	1.320
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990	2.000
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	0.340
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437	0.449
10	Hinge Bracket	0.171inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.176 0.171	0.171
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	0.143
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366	0.379
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	0.124
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	0.0635
15	Hinge Bracket	0.166inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.171 0.166	0.167
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901	0.910
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590	0.596
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	0.126
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140	0.149

DT 18-11-05

Plex 10/30/18 11:31 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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